

Work Order ID 76752

76752

Page 1

November-21-11 10:28:08 AM

Item ID: D2885 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Spacer
 Start Date: 21/11/2011 Start Qty: 400.00 ***400*** Cust Item ID:
 Required Date: 20/12/2011 Req'd Qty: 400.00 ***400*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2885	Rev B								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2885 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

B11-11-22

(400)

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

B11-11-22

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

Subul27

counts
1400
2500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

150	Identify as per dwg & Stock Location: ST25	0.00							
150									
Packaging	Memo	0.00							
Packaging									

400. BL 11-12-5

400X PM 11/12/05

(400X) 11-12-06-SP

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle Spacer

Stop *NS2*

Start Date: 21/11/2011 **Start Qty:** 400.00

400

Cust Item ID:

Required Date: 20/12/2011 **Req'd Qty:** 400.00

400

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**Plan
Code

Accept
Qty

Reject
QtyReject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Number Stamp
11216 2J
MF
11-12-06

Dart Aerospace Ltd

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Picklist Print

November-21-11 10:28:11 AM

Page 1

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Parent Item: D2885

D2885

Parent Item Name: Saddle Spacer

Start Date: 21/11/2011

Required Date: 20/12/2011

Start Qty: 400.00

Required Qty: 400.00

Comments:

IPP A99.10.12New IssueEC

IPP Rev:B Now 6060-T6 06-06-23 JLM

IPP Rev:C waterjet 06-07-23 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

158.8000

0.0257

10.82105

M6061T6S 080

6061-T6 .080 Sheet

**

BIT 11-22

Location

Loc Qty

Loc Code

MAT021

158.8

117285

7.3

119009

151.5

119009

400

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	76752
Description: Saddle Spacer		Part Number:	D2885
Inspection Dwg: D2885 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	.438	2		V MB02	
0.443	+/-0.010	.441	2		V	
Ø0.257	+0.006/-0.001	.260	2		V	
R0.30	+/-0.030	.30	2		R.G.	
0.679	+/-0.010	.680	2		V	
R0.40	+/-0.030	.40	2		R.G.	
0.250	+0.030/-0.000	.250	2		V	
0.672	+/-0.010	.674	2		V	
0.521	+/-0.010	.523	2		V	
1.340	+/-0.010	1.338	2		V	
2.681	+/-0.010	2.679	2		V	
3.71	+/-0.030	3.706	2		V	
R0.38	+/-0.030	.38	2		R.G.	
0.528	+/-0.010	.527	2		V	
0.080°	+/-0.5°	.080°	2			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-11-22	Date: 11/11/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	

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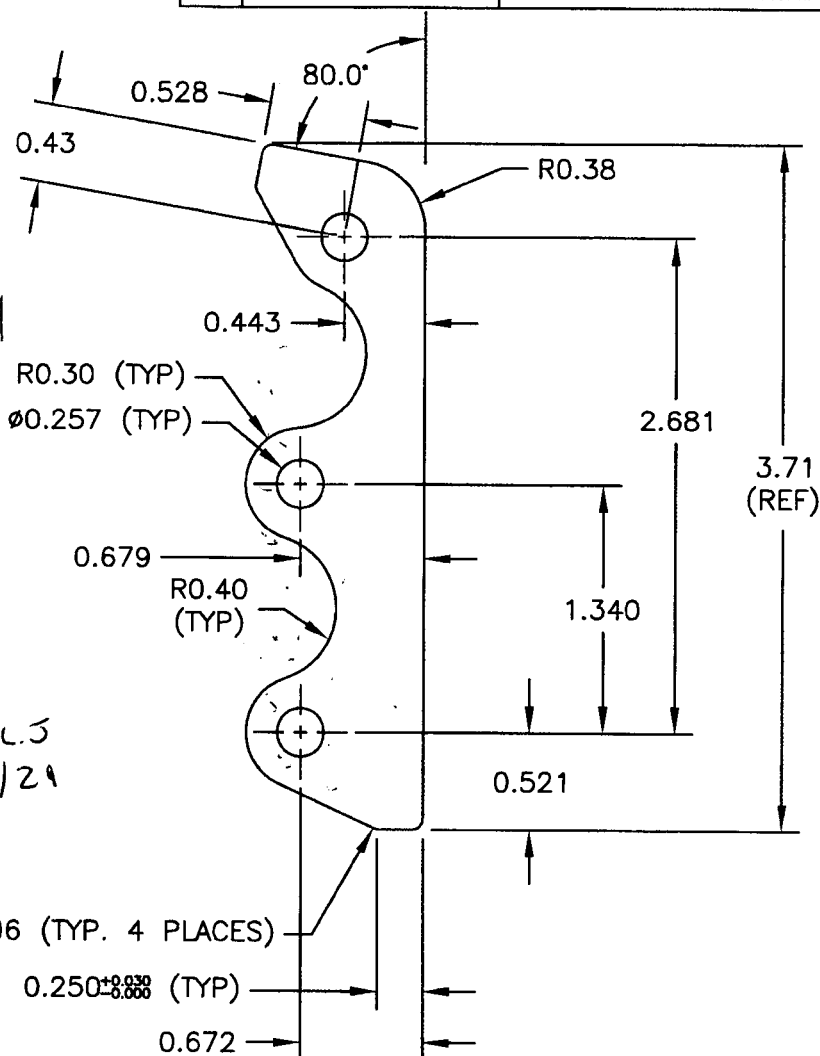
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

06.05.29

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 76752 M.C.S

11/11/29

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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